



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-016
Job Sheet 197908



Part No: D350-636-016

Job Qty: 1 pcs

Part Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 8/8/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D4168-042 REV.C IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC IPP REV:D 13.08.28 PER ECN13-594 DD VERF:JLM IPP REV:E 18.11.12 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	8/8/19		0.00	4.78	Skidtubes - 1		00
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	8/8/19		0.00	0.00	QC 10 - 10		AUG 08 2019 DAS 50 9-89
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	8/8/19		0.00	0.00	QC 5 - 10		AUG 08 2019 DAS 68 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		

Plex 7/18/19 10:43 AM Dart.lajeunesse.marie

140 Handfinish - 1-1 Chemical-B4B	1 pcs	8/8/19	0.00 0.98	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	AUG 08 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	8/8/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BE
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
160 Skidtubes - 2 - B4B	1 pcs	8/8/19	0.00 4.78	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF

140 Handfinish - 1-1 Chemical-B4B	1 pcs	8/8/19	0.00 0.98	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	AUG 08 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	8/8/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	BE
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
160 Skidtubes - 2 - B4B	1 pcs	8/8/19	0.00 4.78	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Plex 7/18/19 10:43 AM Dart.lajeunesse.marie	

					Skidtubes - 5 - B4B	BF
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
					QC 10 - 10	
170 QC 10	1 pcs	8/8/19	0.00 0.00		QC 10 - 18	DAS 68 9-89
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
					QC 5 - 10	
180 QC 5	1 pcs	8/8/19	0.00 0.00		QC 5 - 12	DAS 68 9-89
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	8/8/19	0.00 0.33		Handfinish - 2 - 1 - B4B	SEP 11 2019
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
200 Spray Paint - 2 - B4B	1 pcs	8/8/19	0.00 0.61		Spray Paint - 1 - B4B	AS 17-9-12
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
210 QC 14	1 pcs	8/8/19	0.00 0.00		QC 14 - 15	19-9-13
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
220 Packaging 2-1 - Recelve - B4B	1 pcs	8/8/19	0.00 0.00		Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	

Plex 7/18/19 10:43 AM Dart.lajeunesse.marie

					Packaging 2 - 8 - B4B						
					Packaging 2 - 9 - B4B						
					Packaging 2 - 10 - B4B						
					Packaging 2 - 11 - B4B						
					Packaging 2 - 12 - B4B						
					Packaging 2 - 13 - B4B						
					Packaging 2 - 14 - B4B						
					Packaging 2 - 15 - B4B	all 14-9-20					
					Packaging 2 - 16 - B4B						
					Packaging 2 - 17 - B4B						
					Packaging 2 - 18 - B4B						
					Packaging 2 - 19 - B4B						
					Packaging 2 - 20 - B4B						
					Packaging 2 - 21 - B4B						
					Packaging 2 - 22 - B4B						
					Packaging 2 - 23 - B4B						
					Packaging 2 - 24 - B4B						
					Packaging 2 - 25 - B4B						
					Packaging 2 - 26 - B4B						
					Packaging 2 - 27 - B4B						
					Packaging 2 - 28 - B4B						
					Packaging 2 - 29 - B4B						
					Packaging 2 - 30 - B4B						
					Packaging 2 - 31 - B4B						
					Packaging 2 - 32 - B4B						
					Packaging 2 - 33 - B4B						
					Packaging 2 - 34 - B4B						
					Packaging 2 - 35 - B4B						
					Packaging 2 - 36 - B4B						
					230 Handfinish - 4-1-Assembly-B4B	1 pcs	8/8/19	0.00	0.98	Handfinish - 4 - 1 - B4B	all 14-9-20
										Handfinish - 4 - 10 - B4B	
										Handfinish - 4 - 11 - B4B	
										Handfinish - 4 - 12 - B4B	
										Handfinish - 4 - 13 - B4B	
										Handfinish - 4 - 14 - B4B	
										Handfinish - 4 - 15 - B4B	
Handfinish - 4 - 2 - B4B											
Handfinish - 4 - 3 - B4B											
Handfinish - 4 - 4 - B4B											
Handfinish - 4 - 5 - B4B											
Handfinish - 4 - 6 - B4B											
Handfinish - 4 - 7 - B4B											
Handfinish - 4 - 8 - B4B											
Handfinish - 4 - 9 - B4B											
240 QC 5	1 pcs	8/8/19	0.00	0.00	QC 5 - 10						
					QC 5 - 12						
					QC 5 - 17						
					QC 5 - 18						
					QC 5 - 19						
					QC 5 - 22						
					QC 5 - 24						
					QC 5 - 3						
					QC 5 - 43						
					QC 5 - 49						
					QC 5 - 51						
					QC 5 - 58						
					QC 5 - 68						
					QC 5 - 9						
					QC 5 - 50						
					Plex 7/18/19 10:43 AM Dart.lajeunesse.marie						

				QC 5 - 30		DAS
				QC 5 - 40	SEP 20 2019	40
				QC 5 - 61		9-89
				QC 5 - 81		
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	8/8/19	0.00 0.00	Packaging 1 - 1 - B4B		
				Packaging 1 - 2 - B4B		
				Packaging 1 - 3 - B4B		
				Packaging 1 - 4 - B4B		
				Packaging 1 - 5 - B4B		
				Packaging 1 - 6 - B4B		
				Packaging 1 - 7 - B4B		
				Packaging 1 - 8 - B4B		
				Packaging 1 - 9 - B4B		
				Packaging 1 - 10 - B4B		
				Packaging 1 - 11 - B4B		
				Packaging 1 - 12 - B4B		
				Packaging 1 - 13 - B4B		
				Packaging 1 - 14 - B4B		
				Packaging 1 - 15 - B4B		
				Packaging 1 - 16 - B4B		
				Packaging 1 - 17 - B4B		
				Packaging 1 - 18 - B4B		
				Packaging 1 - 19 - B4B		
				Packaging 1 - 20 - B4B		
				Packaging 1 - 21 - B4B		
				Packaging 1 - 22 - B4B		
				Packaging 1 - 23 - B4B		
				Packaging 1 - 24 - B4B		
				Packaging 1 - 25 - B4B		
				Packaging 1 - 26 - B4B		
				Packaging 1 - 27 - B4B		
				Packaging 1 - 28 - B4B		
				Packaging 1 - 29 - B4B		
				Packaging 1 - 30 - B4B		
				Packaging 1 - 31 - B4B		
				Packaging 1 - 32 - B4B		
				Packaging 1 - 33 - B4B		
				Packaging 1 - 34 - B4B		
				Packaging 1 - 35 - B4B		
				Packaging 1 - 36 - B4B		
260 QC 4	1 pcs	8/8/19	0.00 0.00	QC 4 - 28		
				QC 4 - 58		
				QC 4 - 69		
				QC 4 - 9		
				QC 4 - 46		
				QC 4 - 68		
				QC 4 - 72		
				QC 4 - 74		
				QC 4 - 75		
270 Packaging 3-1 - Stock - B4B	1 pcs	8/8/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B	DAS	
				Packaging 3 - 4 - B4B	74	SEP 23 2019
				Packaging 3 - 5 - B4B	9-89	
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		

May B.

9/23/2019

					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1	8/8/19	0.00 0.00	DC - 1 - B4B		
	pcs			DC - 2 - B4B		SEP 23 2019
280 QC 21 - FG	1	8/8/19	0.00 0.00	QC 21 - FG - 21		
	pcs			QC 21 - FG - 70		
				QC 21 - SA - 53		SEP 23 2019

Part Op 110 - (Skidtubes) 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT
 Descriptions: end per dwg D4168-2 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168 sheet 5 (D4168-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K) 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section R-R and open to 0.500" 5- Drill tow ring hole using DT9616 detail "J" 6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) +.201" (total of one hole per side DT9616) as per dwg D4168. 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 139011 9- Grind welds flush as per Dwg D4168

120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (Skidtubes) 1-Open up holes using hole saw of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168. 2-Open up holes using hole saw of Detail K to 0.750" (total of 4 holes per side) as per dwg D4168. 3- Open float hole to 0.500" using uni-bit (4 per side) and Run on wearplate holes to .375" 4 per side 4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168 (welding instructions on sheet 9) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 1741342 exp. date: 12/08/2019 **ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 139011 9- At section AP-AP drill out x-bolt spacer to 0.404" 10- Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168 12- C'bore section CH-CH. ADJUST TOOLING AS REQUIRED. VERF BY: _____ 13- Deburr holes, ensure tube is free of all scratches before sending to paint. ***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE ***** REF TO W/O BATCH:

170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
 190 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
 200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5204428
 210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
 220 - Receive and inspect for damage + mat'l certs

- 230 - (Assemble as per dwg)1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D4168 SIKAFLEX 241 BATCH: 5200627 EXP DATE: 20-7-25 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M32427 5-Coat all exposed fasteners with "LPS Procyon" batch: M32427
- 240 - (QC5- Inspect part completeness to step on W/O)
- 250 - (Pick Kit) If making a D350-636-216 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1
- 260 - (QC4- 100% Inspect kits for completeness) *****ensure antiseize is on AN8C21A bolts*****
- 270 - Identify and pack for shipping as per PPPD350-636-016 Location : FG071
- 275 - (Document Control) record fwd angle: 84.9 Photocopy blue file and type labels per PPP D350-636-016 CHG 006
- 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	110-Skidtubes - 1	017909
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5197882
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5192776
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	5193773
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5194932
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5186298
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5188611
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5192155
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5186091-1
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	F11138009-2
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5161183
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5160263
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5192376
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5206354
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5185291
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5204546
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5205435
D3873-1	Bushing	7 pcs (7 ea)	230-Handfinish - 4-1-Assembly-B4B	5184192
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5204430
D4170-1	Bushing	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5192272
D4171-1	Bushing	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5175928
MS21043-3	Nut	5 Ea (5 ea)	230-Handfinish - 4-1-Assembly-B4B	5180791
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5199569
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5176221
NAS1149C0332R	Washer (AN960C10L)	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5197757
NAS1149C0363R	Washer (AN960C10)	9 Ea (9 ea)	230-Handfinish - 4-1-Assembly-B4B	5193136
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5135100
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	50760173
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	X 5214421
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5057658
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5199930
AN3C42A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5168418
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5108570
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5184404
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5197063
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5199486
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5215506
				5106718

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-RH	1	7	0
	D2744	1	48	0
	D2739	1	12	0
160-Skidtubes - 2 - B4B	D2743	8	255	0
	D3490-1	4	153	0
	D3490-3	4	46	0
	ALS4-1032-225	4	835	0
	AN3C34A	1	40	0
230-Handfinish - 4-1-Assembly-B4B	AN3C36A	4	255	0
	AN3C6A	4	149	0
	AN6C44A	4	122	0
	AN8C35A	1	30	0
	D2745	8	64	0
	D3488-4	1	13	0
	D3492-1	8	67	0
	D3492-3	8	23	0
	D3631-1	8	376	0
	D3873-1	7	42	0
	D4154-041	1	12	0
	D4170-1	4	49	0
	D4171-1	1	26	0
	MS21043-3	5	934	0
	MS21043-6	4	99	0
	MS21083C8	1	93	0
	NAS1149C0332R	4	4,430	0
	NAS1149C0363R	9	695	0
	NAS1149C0832R	1	294	0
	NAS1515H3L	4	181	0
	NAS1611-010	8	219	0
	NAS1611-013	8	116	0
250-Packaging 1-1 - Pick Kit - B4B	AN3C37A	1	119	0
	AN3C42A	1	49	0
	AN8C21A	2	121	0
	D2741	1	56	0
	D3493-1	2	17	0
	MS21083C8	2	93	0
	NAS1149D0863J	2	375	0
Part Specifications				
Specifications could not be found.				

Plex 7/18/19 10:43 AM Dart.lajeunesse.marie

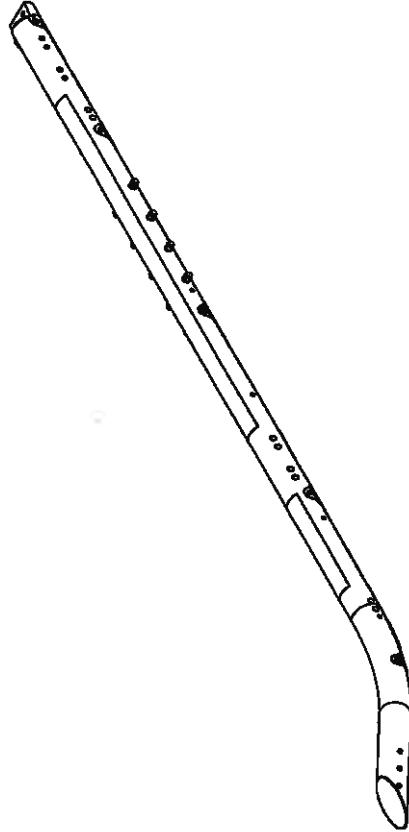
8 7 6 5 4 3 2 1

D

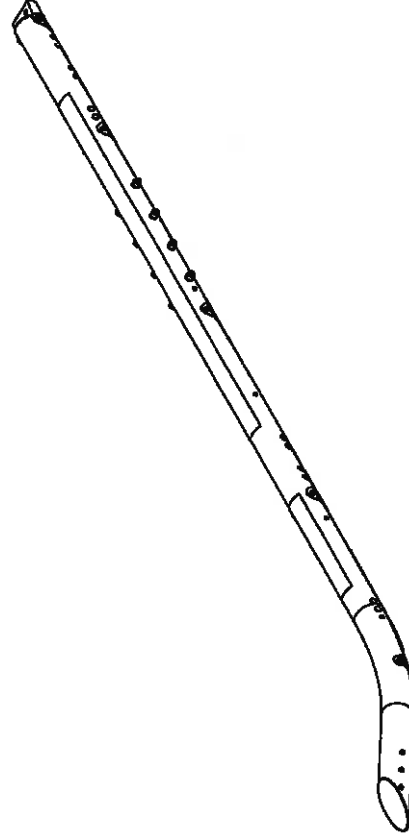
C

B

A



D4168-043 350 SKIDTUBE ASSEMBLY, LH

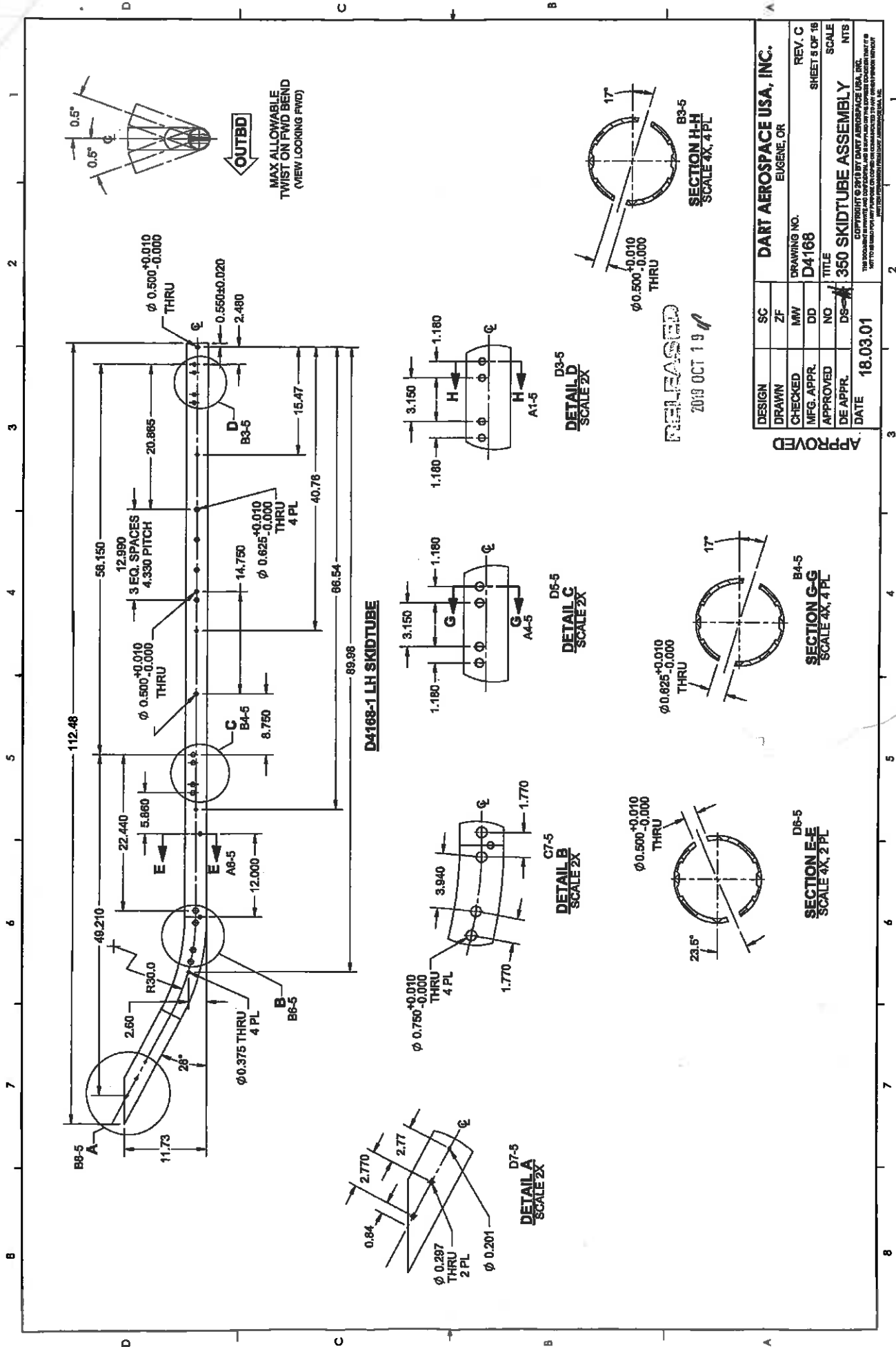


D4168-044 350 SKIDTUBE ASSEMBLY, RH

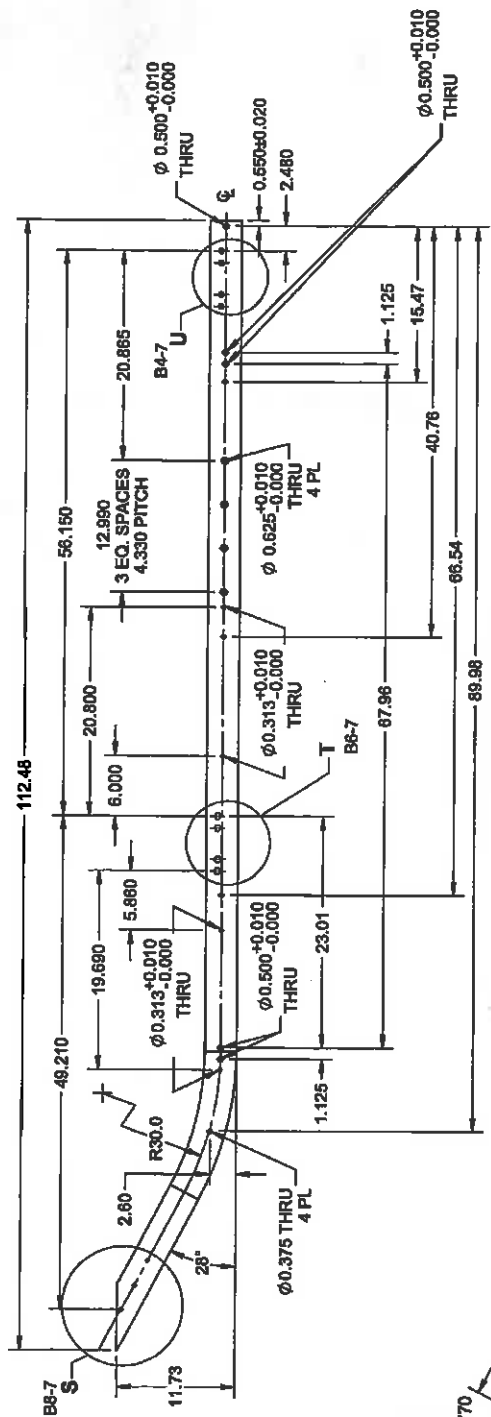
RELEASED
2018 OCT 19

APPROVED

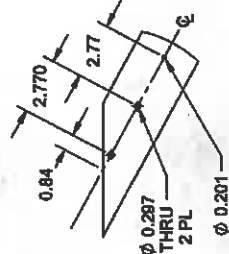
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. G
MFG. APPR.	DD	D4168	SHEET 3 OF 18
APPROVED	NO	TITLE	SCALE
DATE	18.03.01	350 SKIDTUBE ASSEMBLY	NTS
COPYRIGHT © 2018 BY DART AEROSPACE USA, INC. ALL RIGHTS RESERVED. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.			



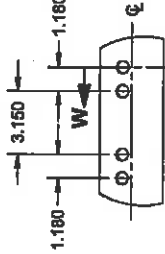
8 7 6 5 4 3 2 1



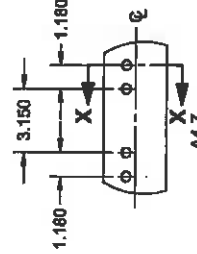
D4168-3 LH SKIDTUBE



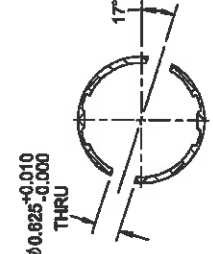
D7-7
SCALE 2X
DETAIL S



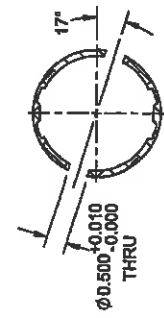
C5-7
SCALE 2X
DETAIL T



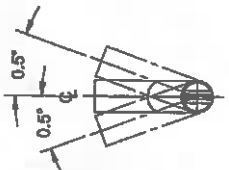
D3-7
SCALE 2X
DETAIL U



B6-7
SCALE 4X, 4 PL
SECTION W-W



B4-7
SCALE 4X, 4 PL
SECTION X-X



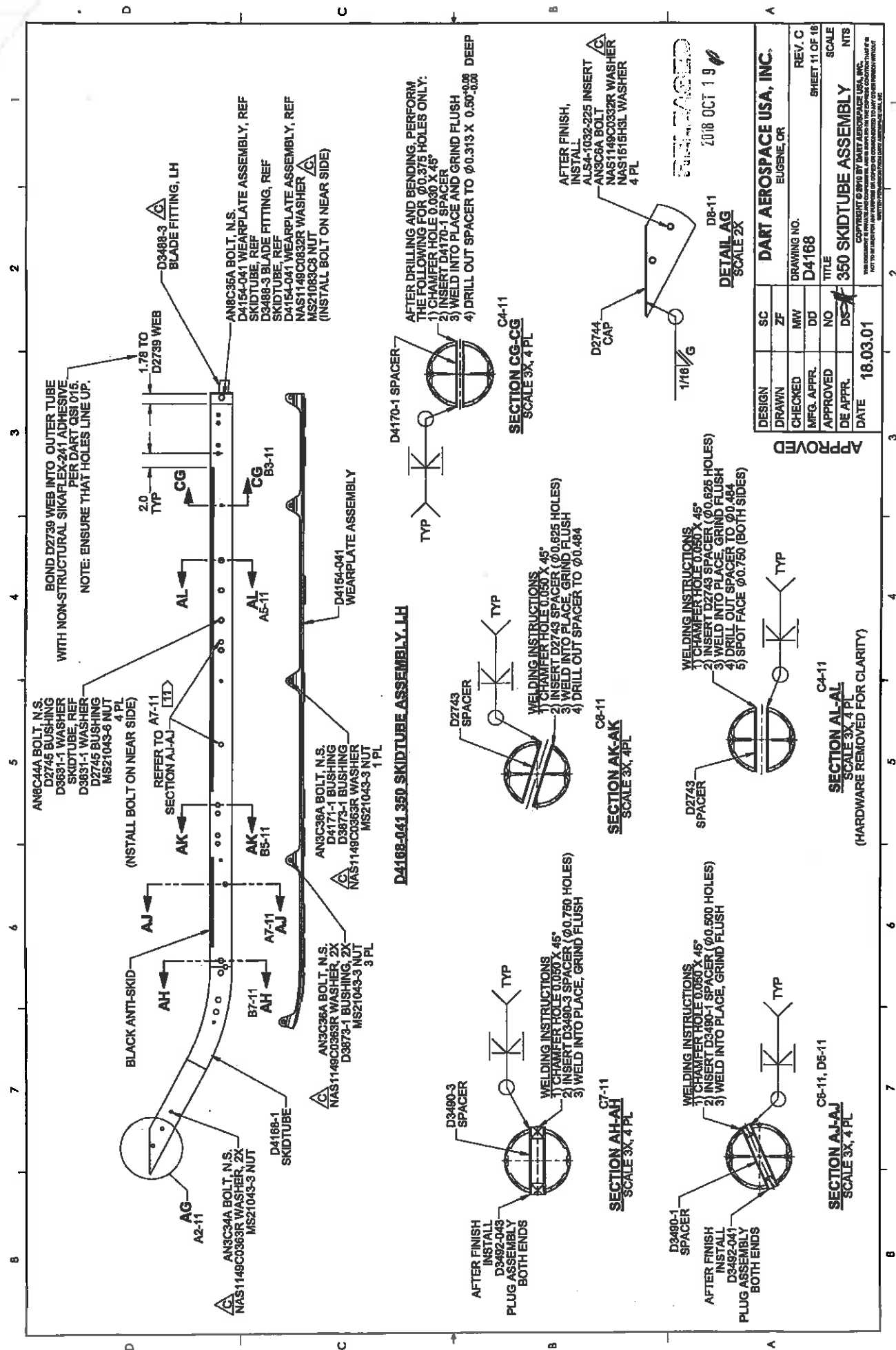
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)

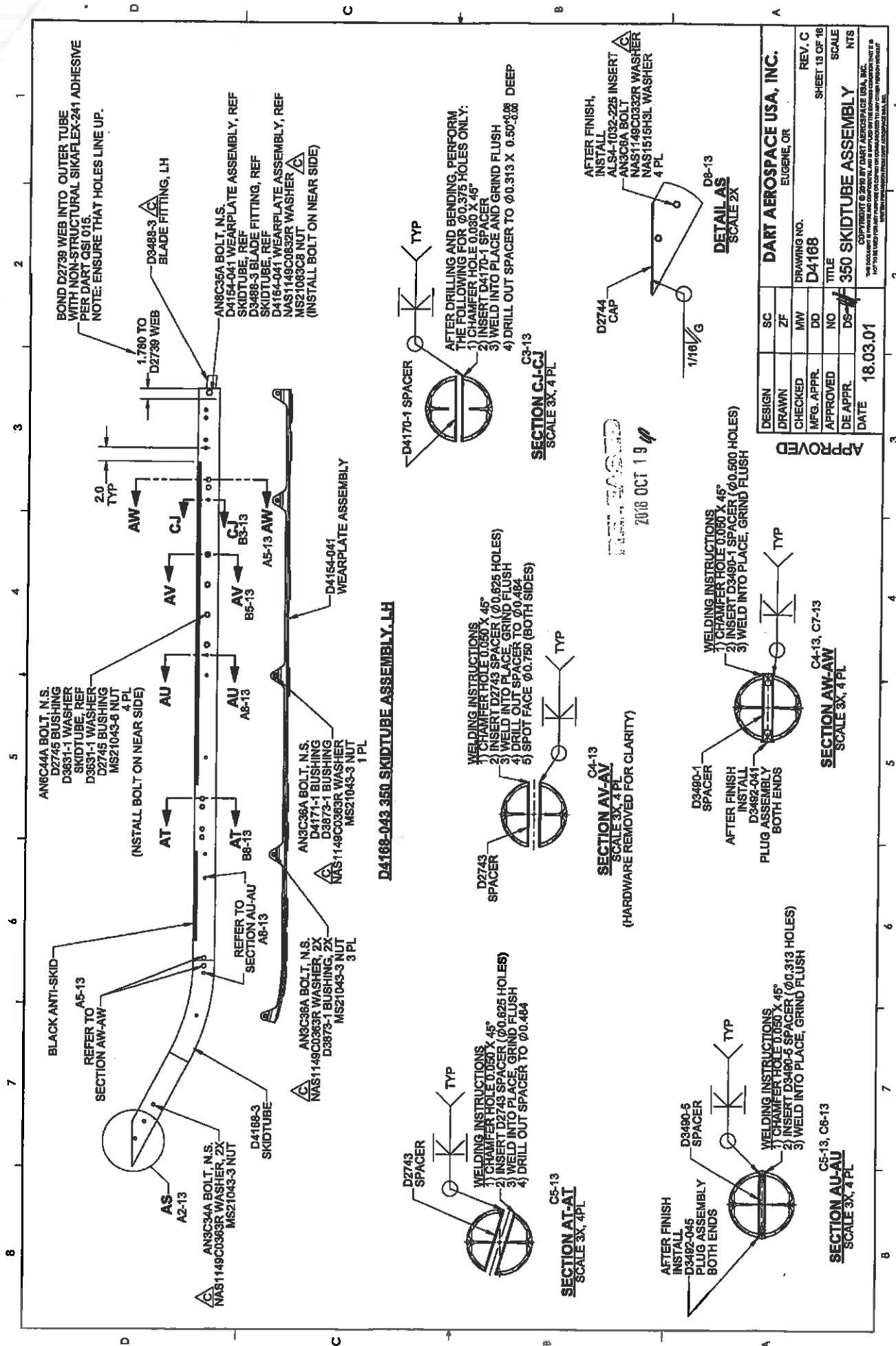
2019 OCT 19

DESIGN	SC	DART AEROSPACE USA, INC.
DRAWN	ZF	EUGENE, OR
CHECKED	MW	REV. C
MFG. APPR.	DD	DRAWING NO. D4168
APPROVED	NO	SHEET 7 OF 18
DE APPR.	DS	TITLE 350 SKIDTUBE ASSEMBLY
DATE	18.03.01	SCALE NTS

APPROVED

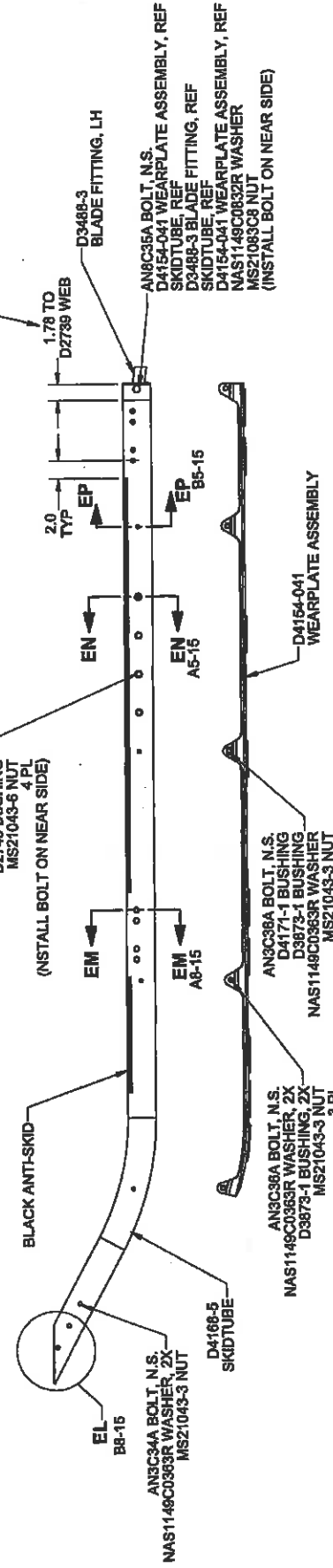
COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.
ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.



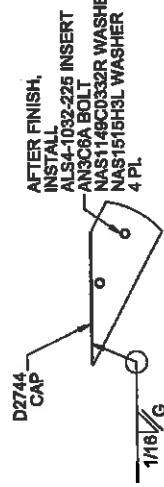


1 2 3 4 5 6 7 8

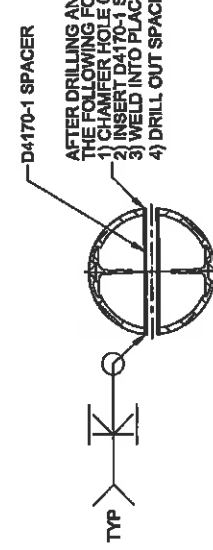
BOND D2739 WEB INTO OUTER TUBE
WITH NON-STRUCTURAL 81KARLEX-241 ADHESIVE
PER DART OSI 015.
NOTE: ENSURE THAT HOLES LINE UP.



D4188-051 350 SKIDTUBE ASSEMBLY, LH



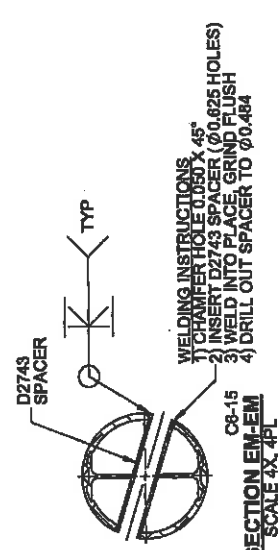
DETAIL EL
SCALE 2X



SECTION EP-EP
SCALE 4X, 4 PL



SECTION EN-EN
SCALE 4X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION EN-EM
SCALE 4X, 4 PL



SECTION EN-EN
SCALE 4X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN	SC	WF	MM	DD	NO	DS	DATE
DRAWN							18.03.01
CHECKED							
MFG. APPR.							
APPROVED							
DE APPR.							

APPROVED

DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. D4188

REV. C

SHEET 15 OF 18

SCALE

NTS

350 SKIDTUBE ASSEMBLY

Copyright © 2011 by DART Aerospace USA, Inc.

ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.

2010 OCT 19



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAUISER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAUISER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
1						1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1	1							D4168-1	SKIDTUBE WELDMENT, LH
*1		1						D4168-2	SKIDTUBE WELDMENT, RH
*1			1					D4168-3	SKIDTUBE WELDMENT, LH
*1				1				D4168-4	SKIDTUBE WELDMENT, RH
*1					1			D4168-5	SKIDTUBE WELDMENT, LH
*1						1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149CO863J	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR
COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: K
Date: 18.04.04

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
*90	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A			1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	8	D3873-1	BUSHING
94A			1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96							4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS

² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS

³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

© COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: **K**
Date: 18.04.04

Change Record

PAGE 1 OF 1

Part Number: D350-636-015/-016

Description: SKIDTUBE STD LH/RH w/ TRAINING WEARPLATE

[illegible]